

Work Order ID 53561

November 9, 2009 10:35:59 AM



Page 1

Item ID: D206-667-101TRN

Accept



Setup Start



Revision ID: C

Item Name: Crosstube Turning Detail

Stop



Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan: 

Date: 09-11-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D206-667-141	Rev C								

100

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Fill tube with sand & install plugs DT8534 on both ends as per Folio FA083□2-Turn first side as per Folio FA083□3-File down transition lines smooth.

Q.m 09-11-210

110

0.00



QC1- Inspect dimensions to dimension sheet

QC

Memo

0.00

Quality Control

Q.m 09-11-210

120

0.00



MORI SEIKI CNC LATHE LARGE

Mori Seiki

Memo

0.00

Mori Seiki CNC Lathe Large

1-Turn second side as per Folio FA083□2-File down transition lines smooth.
□
3-Remove sand and plugs

Q.m 09-11-210

Work Order ID 53561

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Item ID: D206-667-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 QC Quality Control	QC1- Inspect dimensions to dimension sheet Memo	0.00 0.00							<u>OK</u> <u>09-11-210</u>
140 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00							<u>1 - -</u> <u>AWM9-11-23</u>
150 HandFXtube Hand Finishing Crosstubes	Crosstubes Chemical Conversion Memo	0.00 0.00							<u>1 - -</u> <u>AWM9-11-23</u>

Work Order ID 53561

November 9, 2009 10:36:00 AM



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Item ID: D206-667-101TRN

Accept



Setup Start



Revision ID: C

Stop



Item Name: Crosstube Turning Detail

Start Date: 09/11/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 19/11/2009 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

1 11/9/23

170

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and stock in kanban rack ☐ Location: X-TUBE CELL

1 MF 09-11-23

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/11/24

MF 09-11-23

Picklist Print

November 9, 2009 10:36:03 AM

Page 1

Work Order ID: 53561



Parent Item: D206-667-101TRNRevC



Parent Item Name: Crosstube Turning Detail

Start Date: 09/11/2009

Required Date: 19/11/2009

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6001-105RevA		Manufactured	No			110	Each	30.0000	1.0000			

Crosstube, Material

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

30

25661

3

29115

27

AWM 9-11-2009 (1)

DART AEROSPACE LTD		Work Order:	53541
Description: Crosstube Assembly (206B High Fwd)		Part Number:	D206-667-141
Inspection Dwg: D206-667-141 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	2.240	+0.005/-0.000	2.240	/		
	2.074	+0.005/-0.000	2.079	/		
	2.074	+0.005/-0.000	2.079	/		
	2.114	+0.005/-0.000	2.117	/		
	2.154	+0.005/-0.000	2.159	/		
	2.194	+0.005/-0.000	2.198	/		
	2.234	+0.005/-0.000	2.239	/		
	0.110	+/-0.010	0.110	/		
	0.300 x 30°	+/-0.010	0.300 x 30°	/		
	R0.063	+/-0.010	R0.063	/		
	R0.500	+/-0.010	R0.500	/		
	4.438	+/-0.030	4.438	/		
SIDE B	2.240	+0.005/-0.000	2.240	/		
	2.074	+0.005/-0.000	2.079	/		
	2.074	+0.005/-0.000	2.079	/		
	2.114	+0.005/-0.000	2.119	/		
	2.154	+0.005/-0.000	2.159	/		
	2.194	+0.005/-0.000	2.198	/		
	2.234	+0.005/-0.000	2.239	/		
	0.110	+/-0.010	0.110	/		
	0.300 x 30°	+/-0.010	0.300 x 30°	/		
	R0.063	+/-0.010	R0.063	/		
	R0.500	+/-0.010	R0.500	/		
	4.438	+/-0.030	4.438	/		
	93.18	+/-0.020	93.180	/		

Measured by:	Q.M	Audited by:	ANM	Prototype Approval:	N/A
Date:	09.11.21	Date:	9-11-21	Date:	N/A
Rev	Date	Change	Revised by	Approved	
A	06.10.24	New Issue (P/O D206-667-101)	KJ/JLM	BE	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

93-430"

Item	Qty -141	Part Number	Description
1	X	D206-667-141	CROSSTUBE ASSEMBLY (206B HIGH FWD)
2	1	D6001-105	CROSSTUBE
3	2	D2873-043	NUT PLATE
4	2	D2873-045	NUT PLATE
5	2	D2891-1	SUPPORT
6	4	D3595-063-395	RUBBER CUSHION
7	4	MS21920-20	CLAMP (OR MS21920-21)
8	14	MS20601AD4W8	RIVET (OR NAS9302B-4-8)
9	A/R	MAGNOBOND 6398	ROCKWELL SPECIFICATION RBO-120-023 ADHESIVE (TEXTRON/BELL SPEC. 299-947-100, TYPE II, CLASS 2 ADHESIVE)

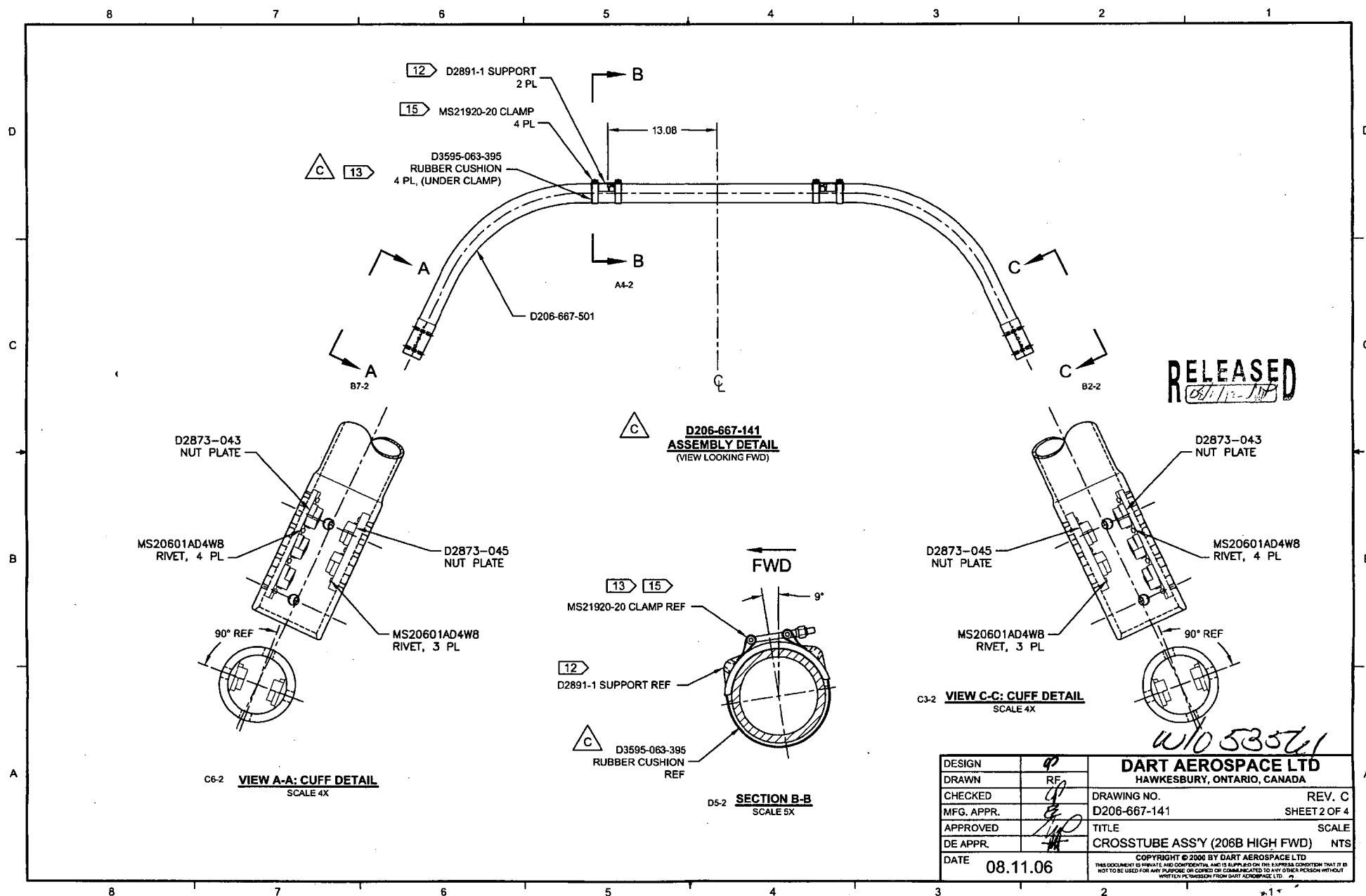
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 53501
2102-11-9

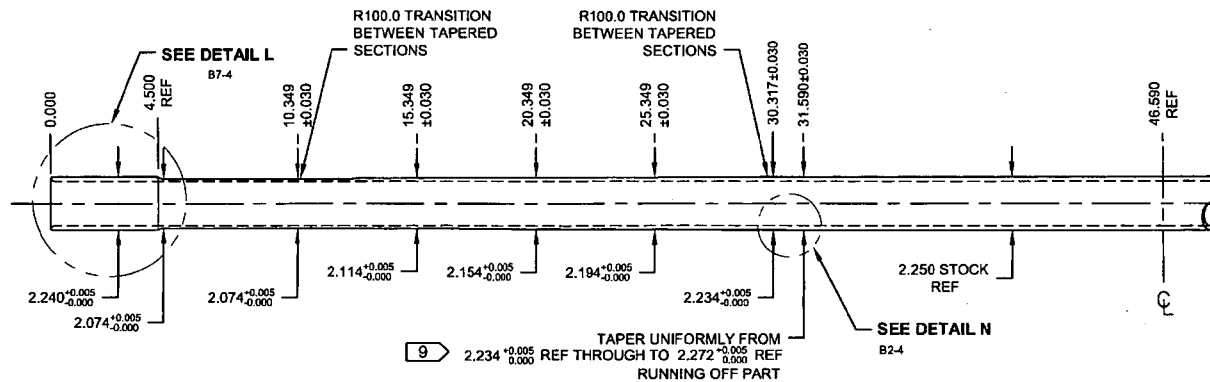
GENERAL NOTES:

- 1) MATERIAL: MANUFACTURED FROM D6001-105
FINISHED LENGTH = 93.18±0.020
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
- 6) IDENTIFICATION: SCRIBE DART PART NUMBER "D206-667-141" AND BATCH NUMBER ON INSIDE OF CUFF USING VIBRATING STYLUS.
- 7) WEIGHT: 11.3 lbs
- 8) PART IS SYMMETRIC ABOUT CENTERLINE.
- 9) RUN CUTTER OFF PART WHERE INDICATED. BLEND OUT EDGE LONGITUDINALLY. TRANSITION SHOULD BE SMOOTH.
- 10) BEND PROGRESSIVELY WITH A MINIMUM OF 12 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 11) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 12) INSTALL D2891-1 SUPPORT USING 0.03" TO 0.06" THICK LAYER OF MAGNOBOND 6398 PER QSI 015. LET CURE FOR 12 HOURS AFTER INSTALLATION AND PRIOR TO PACKAGING.
- 13) INSTALL MS21920-20 CLAMPS (OR -21) WITH D3595-063-395 RUBBER CUSHIONS TO SECURE THE D2891-1 SUPPORT ON TOP SIDE OF THE CROSSTUBE. ENSURE CLAMP MECHANISMS ARE LOCATED ON CROSSTUBE SUPPORTS.
- 14) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 15) TORQUE CLAMPS 80 TO 100 IN-LB. ENSURE AT LEAST 1.5 THREADS ARE SHOWING IN SAFETY AND THAT NUT HAS NOT BOTTOMED-OUT AFTER TORQUING.

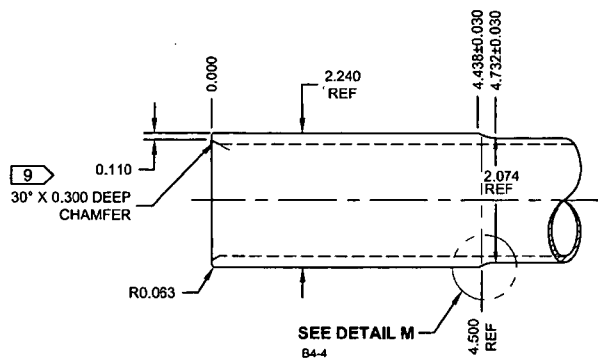
RELEASED
05/11/12/11/12

C	REVISE GENERAL NOTES/PART LIST (ZN D7-1); REORGANIZED VIEWS AND REFORMATTED DRAWING TO CURRENT STANDARDS. D3595-063-395 WAS D2856-400-694 (ZN D6-2 & A5-2); REMOVED REF. & ADD TOLERANCES (ZN C4-3, C5-3 & D3-3); RELOCATED FLAG #6 (ZN A8-3) PER NCR 210; MOVED TURNING DETAIL & UPDATED TOLERANCE TO SHEET 4.	RF	08.11.06
B	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKUDTUBES	PH	05.07.26
A	NEW ISSUE	CP	00.11.17
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 1 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
DE APPR.	RF	COPYRIGHT © 2006 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	
DATE	08.11.06		

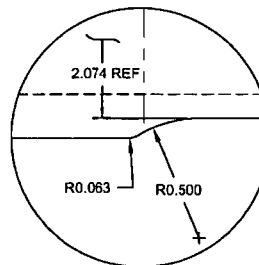




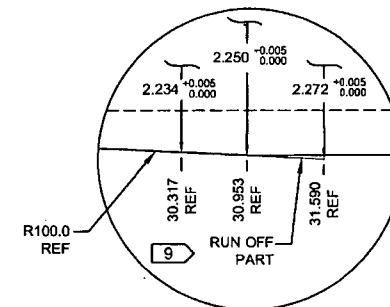
△ TURNING DETAIL



DETAIL L:
D7-4 CROSSTUBE CUFF
NOT TO SCALE



DETAIL M:
A6-4 CUFF TRANSITION
NOT TO SCALE



DETAIL N:
C4-4 TAPER RUN-OFF
NOT TO SCALE

W10-53561

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	RF	D206-667-141	SHEET 4 OF 4
MFG. APPR.	RF	TITLE	SCALE
APPROVED	RF	CROSSTUBE ASS'Y (206B HIGH FWD)	NTS
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DATE	08.11.06		

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08/11/12